

## How to Order American Swiss Files

Select from catalogue, shape, length, cut; also width and gauge of file required for your work.

All files are measured by length of cut, except Die Sinkers' Riffles, Silversmiths' Riffles, Needle, Escape-ment, and size A and B Machine Files which are measured over all.

For comparative cuts of American Swiss and common files, see page 11; common American Files are not made in cuts above No. 4.

If in doubt as to the proper file to use for your particular class of work, write us stating the kind and shape of material used and the finish, as well as the description of your work.

*Be sure to specify the AMERICAN  
SWISS BRAND made by the  
American Swiss File & Tool Co.  
410-416 Trumbull Street  
ELIZABETH, N. J.*

*Order from the nearest Distributor*



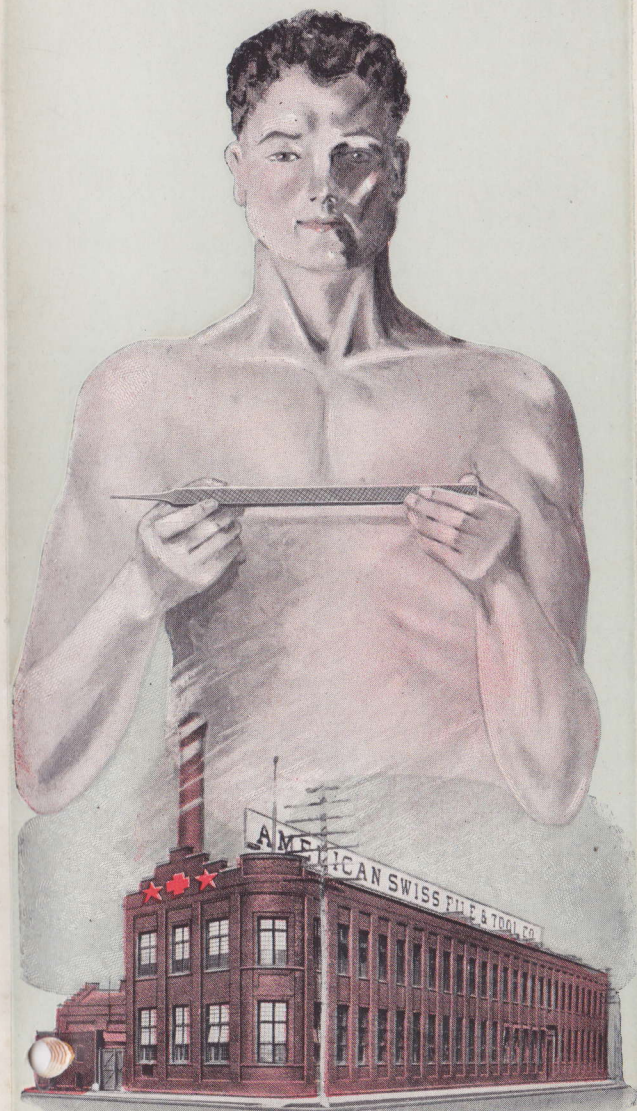
Sold by the Foremost Dealers in  
Mill and Machinist Supplies



Gold Medal awarded to us at  
St. Louis World's Fair, 1904



# FILES of PRECISION







## The Origin of American Swiss Files

**T**HIRTY YEARS AGO, there were no manufacturers in America who could produce a file equal to the imported Swiss file of the same quality and precision. A quality file, in those days had to be imported.

For this reason, in 1899 the late Edward P. Reichhelm, founder and president of the American Swiss File and Tool Company, conceived the idea that a high grade tool makers' and die sinkers' file could be made in the United States, just as well as in Switzerland or any other foreign country. This in spite of the fact that numerous attempts had previously been made in this country to displace the imported file with but limited success.

Many of Mr. Reichhelm's advisors tried to persuade him not to attempt to put his ideas into actual practice, but the founder of the American Swiss File & Tool Company, with that confidence typical of American enterprise, was sure that a very desirable industrial field could be better served by methods which he had developed.

The position American Swiss files of precision now hold is second to none in the industrial field where quality and service is the keynote. Foremost industrial firms who years ago were enthusiastic users of imported Swiss files are now even more enthusiastic over the American Swiss files and will not have a foreign file in their shops.

## Files of Precision

American Swiss files of precision should in no way be confused with the ordinary commercial American file, which not only costs less but which makes no claim to the superior hardness, cut and lasting qualities of a file of precision.

Precision files, as manufactured by the American Swiss File and Tool Company, are made with as much care as the finest tools. There are between 25 and 30 operations in the process of manufacture.

Extreme care is taken in each operation and especially in the automatically controlled heat treatments so that each file will have the same hardness, a uniform excellence and be identical to other American Swiss files of the same shape and cut.

In fact so uniform has been the quality and hardness of American Swiss files that several large tool manufacturers are using them exclusively for testing the hardness of their own product. This uniformity is assured by the rigid inspection and tests given to each individual file before leaving the American Swiss File & Tool Company factory.

On production work, the uniformity of American Swiss files not only works a saving in filing costs, but gives a uniformity in the work turned out. In large manufacturing plants where American Swiss files are used on production work and where a

careful study of the filing problems has been made, the proper dimensions and shape of American Swiss file for each particular operation has been worked out. This is possible because of the continued uniformity of American Swiss file.

Having once determined just what pressure is necessary to get the proper "cut" or "bite", and produce the best results in the production work, the workman is then always assured of getting the same quality file day in and day out—or year in and year out. Only strict uniformity of product, such as the American Swiss guarantees, can make this possible.

## 25% to 30% Longer Life

A survey among users of American Swiss files has shown that manufacturers are getting on a conservative average over 25% longer life from American Swiss files. This makes a worthwhile saving in filing costs even in the small shops. One small Chicago tool and die making shop employing only a half-dozen men, saved \$150 last year by using American Swiss files. Such savings as this far overbalance the small added cost of buying a really quality precision file.

When you add to this, that the satisfaction of fine tools in the hands of a mechanic not only inspires him to a higher grade of workmanship but allows him to turn out more work with less effort, the savings possible in the use of American Swiss file are worth considerable thought.

## 2400 different sizes, shapes and cuts to select from

To be able to select the exact file for a given job, to pick a file best suited to reach into the small slots and intricate corners of a piece of work, results in a saving of both



time and labor. It also improves the grade of work.

The 2400 different sizes, shapes and cuts of American Swiss files carried in stock present a wide range of selection and give a service to the trade only second to the material and workmanship put into an American Swiss file.

You will find in the listings in this folder just the right file for the job. Investigate your file situation and see how this wide range of selection can work a saving in your file costs.

## Have you a file problem?

In the larger manufacturing plants, where special attention and study is given to filing problems, where careful tests are made to select the best possible size, shape and cut for each operation, savings in skilled labor, improvements in workmanship and an increase in the life of the file have resulted.

If you are in doubt as to just what file will make this improvement in your shop, the American Swiss File & Tool Company Service Engineers will be pleased to help you solve your problem.

Just write stating the kind and shape of material used and the finish desired, as well as give a description of your work. You will in no way be obligated and we will be pleased to recommend the file to give the best results.

## What others have done with American Swiss Files

American Swiss files have been the choice of discriminating mechanics for over 28 years.

They have learned to know from experience that the American Swiss trade mark



on files of precision backs up American Swiss claims of uniform hardness and quality.

A wide range of industries have found American Swiss files a necessity in their work.

A few of their endorsements follow. Note the wide range of industries covered.

### From a prominent carburetor manufacturer

"We are daily saving money through the use of American Swiss Files."

### From a well known machine manufacturer

"After twelve years of constant use we are pleased to say we save approximately 30% on file costs by using American Swiss Files."

### From a leading tractor manufacturer

"We can always depend on them being true temper and uniform throughout and we are well satisfied with them."

### From a high grade tool manufacturer

"The American Swiss files play an important part in our work and aid us to maintain the high standard of quality for which our products are known."

### From a Detroit auto parts manufacturer

"We have found them to be uniformly satisfactory as to quality, life and cost."

### From a world famous Radio Set manufacturer

"We have used American Swiss files for almost six years and have found them to be most satisfactory, superior to any other so-called Swiss Pattern Files manufactured in this country and equal to the imported file."



### **From a manufacturer of milling cutters**

"We have standardized on American Swiss Files for this work because of the combination of superior quality combined with reasonable price, and also selected them for use in our most critical places of testing for hardness. In these two instances we are very particular."

### **An extraordinary saving made by a prominent clock maker**

"We find that on certain classes of work American Swiss Files last anywhere from 25% to 100% longer than some other files."

### **From a leading Detroit auto manufacturer**

"The American Swiss Files are uniform in temper—quality and durability.

We are more than satisfied with them as they save us time and money."

### **From a stoker manufacturer**

"This choice has resulted in from 25% to 35% savings in file costs and it is remarkable the way the American Swiss files stand the abuse and hard usage which we subject them to. Through their use we have forgotten our file troubles."

### **From a Purchasing Agent**

"We take this opportunity to place ourselves on record as being a satisfied user of your product. We have found American Swiss Files to be uniformly satisfactory as to quality, life and cost."

### **From an American Swiss file distributor**

"Very glad indeed, to be able to send you one of the largest checks of the year. . . . The size of our remittance merely reflects the enthusiastic interest on the part of our entire sales organization in your line."

## **Worth While Information**

**T**HIS BOOKLET is issued for users of files, to aid in selecting the various sizes, shapes, cuts and dimensions of Precision Files. The so-called Swiss type files have been largely confined to Jewelers, Die-Sinkers and Tool Makers. Many other lines of manufacturing, however, require files of precise dimensions for use on metal parts where accuracy and finish are indispensable.

Orders received by this Company indicate very clearly that the selection of the proper files for their use has received comparatively little consideration. Although it is generally understood that an order must specify the shape, length and cut, it is important that width or thickness be specified in many instances. Comparatively few file users are aware of the fact that files are available in specific dimensions which are accurate and reliable. Including specials, this Company makes nearly 3000 different shapes, sizes and cuts of Precision Files.

In order to obtain the best possible result it is very important that the proper file be selected for each operation, especially as to cut and dimension. Although there is supposed to be a standard of the comparative cuts of all Swiss type files, it is quite possible that a variation will exist between cuts of the corresponding numbers of different manufacturers. It must also be borne in mind that different cuts are "comparative" and will vary with different lengths of files. Corresponding cuts will be coarser in the longer than in the shorter files. Comparison of cuts must, therefore, be made by matching with files of similar



lengths. The proper cut for the work to be performed is very important from the standpoint of obtaining the desired result, as well as getting the most out of the file.

When buying files, the purchasing department will naturally buy whatever the shop requisition calls for at the lowest price when no particular make is specified. If no complaint is received from the operating department, it is assumed that the files are satisfactory, though their use may result in three times the expense, unless particular attention is paid to the quality and results obtained.

A case recently occurred in one of the prominent automobile gear factories; a considerable quantity of common knife-shape files were being used for marking the teeth of timing-gears. The production of the factory required the use of two files per day. American Swiss files were tried out and we received a report that one file would last 10 times as long as a common file on this particular work; in addition to saving the time of the operators. Similar conditions exist in most every manufacturing plant and are well worth serious consideration.

In determining the quality of files there is only one method of making a satisfactory test and that is by actual use in the hands of the mechanic. Files made for hand use are so designed that the pressure necessary to "cut" or "bite" is determined by the operator. Files designed for use in filing machines usually have a different arrangement of teeth, so as to withstand the constant pressure and the difference between the machine and hand stroke.

File shapes may be classified under the general headings: Flat, Square, Three Square and Round. Variations and combinations of these make up the variety of different shapes.

These shapes have three general characteristics in widths and thicknesses, being tapered in both width and thickness; tapered in thickness and parallel in width or parallel in both width and thickness. The descriptions and cuts in this folder show clearly the parallel and tapering dimensions of the various shapes. Also which sides are "cut" or "safe" and whether the edges are round or square.

All Precision Files are "double-cut" except certain shapes not classed as Swiss type but listed as Mill, Taper saw and open-cut files which are single cut, and have been added to the line because of the insistent demand for superior quality in these kinds of files.

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*Sold by the leading  
Machinery, Tool and Supply  
Dealers*

**American Swiss File & Tool Co.**  
**410-416 Trumbull Street**  
**ELIZABETH, N. J.**



## Guarantee of Quality

Our Guarantee of Quality is upheld, *because* we do not make Files *for a price*, but make the best files we can make by the best equipment and workmanship obtainable, and fix our selling price according to our own cost of production, *regardless* of prices made by the makers of other files. Files not up to the standard in any respect are subject to return at our expense, *if the fault found is pointed out to us*, as a means of keeping our inspecting department wide awake.






## Prompt Delivery

Prompt delivery is assured *because* we carry a large and complete stock of all shapes, sizes and cuts specified in this catalogue, and our system is such that the files sold are promptly replaced by our factory. This applies to all cuts *except No. 8*, which, being rarely called for, is made when ordered.

## Specials

**Specials.**—Files differing in *any respect* from those listed and carried in stock are "*Specials*," on which we will be pleased to estimate on receipt of your specifications, samples or drawings.

COMPARATIVE CUTS OF AMERICAN SWISS FILES WITH COMMERCIAL FILES

No. 00 Bastard	0	1 Second Cut	2 Smooth	3 Super Smooth
				

Am. Swiss Comm.

Am. Swiss

COMMERCIAL FILES HAVE NO EQUIVALENTS OF OUR NOS. 4<sup>th</sup> to 8<sup>th</sup>

No. 4

No. 5

No. 6

No. 7

No. 8

5 6 7  
COMMERCIAL FILES HAVE NO EQUIVALENTS OF OUR NOS. 4 to 8

## WARDING FILES

	2½	3	3½	4	4½	5	6	7	8	10
Length in inches.....										
Thickness B. & S. Gauge.....	20	18	16	14	14	13	11	10	10	8
" "	"	"	"	"	"	"	"	"	"	"
" "	"	20	18	16	16	15	13			
" "	"	"	"	"	"	"	"	"	"	"
" "	"	22	20	18	18	14	14			
" "	"	"	"	"	"	"	"	"	"	"
" "	"	"	20	20	16	16				

## EQUALING

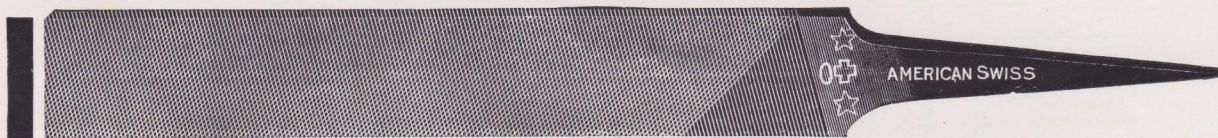
Length in inches.....	2½	3	3½	4	4½	5	6	8
Thickness B. & S. Gauge.....	20	18	16	16	15	13	10	10
" " .....	"	"	"	18	15	12	12	14
" " .....	"	"	"	20	"	"	"	"
Length in inches.....	3	4	5	6	8			
Thickness B. & S. Gauge.....	14	9	11	10	8	Cuts carried		
" " .....	16	to	13	12	10	in stock		
" " .....	18	26	15	14	12	Nos. 0 and 2		
" " .....	20	"	18	16	"	"		
Width.....	¾	7⁄16	1½	9⁄16	¾			
Length in inches.....	3	4	5	6	8			
Thickness B. & S. Gauge.....	16	14	11	10	8	Cuts carried		
" " .....	18	16	13	12	10	in stock		
" " .....	"	18	15	14	12	Nos. 0 and 2		
" " .....	"	20	"	16	"	"		
Width.....	¾	7⁄16	1½	9⁄16	¾ <sup>m</sup>			



## HAND FILES

Cut No. 00 to 6 and 8

Length in inches..... 3    3½    4    4½    5    6    7    8    10    12    14



Widths..... 13/32    15/32    19/32    19/32    21/32    3/4    7/8    1    1 1/8    1 1/4    1 1/2"

## REGULAR PILLAR FILES

Cut No. 00 to 6 and 8

Length in inches..... 2½    3    3½    4    4½    5    6    7    8    10    12



Widths..... 7/32    1/4    5/16    3/8    13/32    7/16    1/2    9/16    5/8    3/4    1"

## NARROW PILLAR FILES

Cut No. 00 to 6 and 8

Length in inches..... 2½    3    3½    4    4½    5    6    7    8    10    12



Widths..... 5/32    3/16    3/16    7/32    15/64    1/4    9/32    5/16    3/8    1/2    5/8"

## EXTRA NARROW PILLAR

Cut No. 00 to 6 and 8

Length in inches..... 2½    3    3½    4    4½    5    6    8    10    12



Widths..... 1/8    5/32    5/32    11/64    11/64    3/16    7/32    5/16    3/8    1/2"

## Pillar Files Are Made in the Following Widths:

Length in inches.....	2½	3	3½	4	4½	5	6	7	8	10	12
Width in inches.....	5/32 7/32	1/8 5/32 3/16 1/4	5/32 3/16 5/16	1/8 11/64 3/16 7/32 5/16 3/8 1/2	11/64 15/64 13/32 5/16 7/16	3/16 1/4 7/32 9/32 5/16 11/32 3/8 1/2	1/8 3/16 1/4 7/32 9/32 5/16 11/32 3/8 1/2	5/16 9/16 1/2 3/4 5/8 3/4 1	3/8 1/2 5/8 3/4 5/8 3/4 1	1/2 5/8 3/4 5/8 3/4 1	5/8 3/4 5/8 3/4 1



## HALF-ROUND FILES

Cut No. 00 to 6 and 8  
Length in inches.....

2½ 3 3½ 4 4½ 5 6 7 8 10 12



Widths..... ¼ 11/32 13/32 7/16 ½ 17/32 5/8 ¾ 13/16 1 1 3/16"

## SLIM HALF ROUND

Cut No. 00 to 6 and 8  
Inches.....

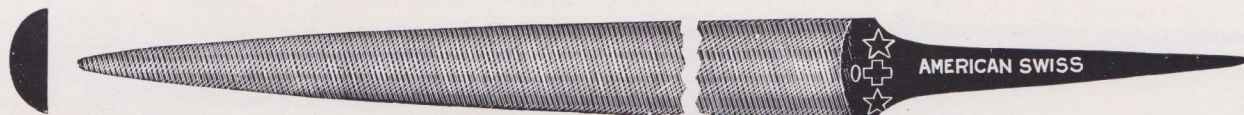
3 3½ 4 4½ 5 6 8



Widths..... ¼ 5/16 13/32 13/32 7/16 ½ ¾"

## HALF-ROUND RING, 7 INCHES

Cut No. 00 to 2, 3, 4 and 6. Made in one size only. Length 7" by ½" wide



## CROSSING FILES

Cut No. 00 to 6 and 8  
Length in inches.....

2½ 3 3½ 4 4½ 5 6 7 8 10 12

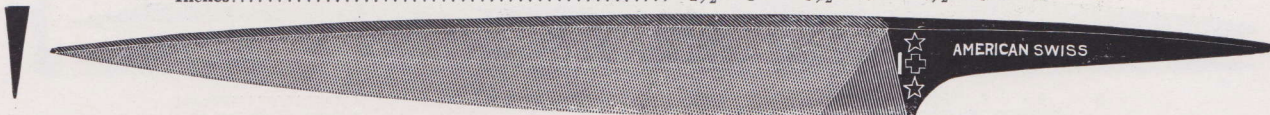


Widths..... 7/32 5/16 3/8 7/16 ½ 17/32 5/8 ¾ 13/16 1 1 3/16"

## KNIFE

Cut No. 00 to 6 and 8  
Inches.....

2½ 3 3½ 4 4½ 5 6 8

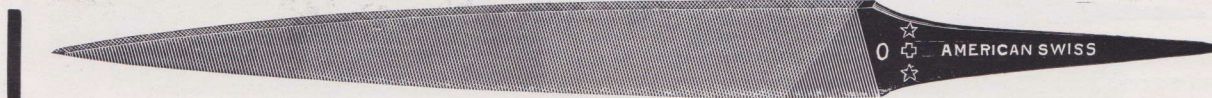


Widths..... 11/32 3/8 7/16 ½ 9/16 9/16 11/16 7/8"

## WARDING

Cut No. 00 to 6 and 8  
Inches.....

2½ 3 3½ 4 4½ 5 6 7 8 10 For Thickness See Page 12



Widths..... 5/16 3/8 7/16 ½ 17/32 9/16 5/8 11/16 ¾ 1"

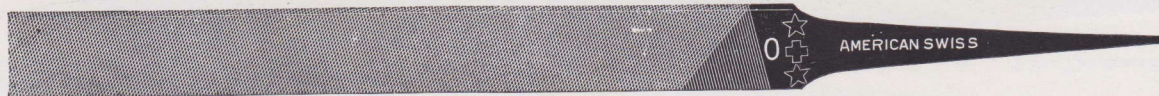


# EQUALING

Cut No. 00 to 6 and 8  
Inches.....

2½ 3 3½ 4 4½ 5 6

8 For Thickness See Page 12



Widths..... ¼ ⅜ 13/32 7/16 ½ 17/32 19/32 ¾"

# BARRETTE

Cut No. 00 to 6 and 8  
Inches.....

2½ 3 3½ 4 4½ 5 6 8

Cut on flat side only



Widths..... ¼ ⅜ 7/16 ½ 17/32 9/16 5/8 13/16"

# CANT

Cut No. 00 to 6 and 8  
Inches.....

3 4 5 6 8

Three sides cut



Widths..... ¼ 13/32 17/32 19/32 25/32"

# PIPPIN

Cut No. 00 to 6 and 8  
Inches.....

3 3½ 4 5 6 8



Widths..... 7/32 ¼ 9/32 5/16 3/8 ½"

# CROCHET

Cut No. 00 to 6 and 8  
Inches.....

2½ 3 3½ 4 4½ 5 6 8 10



Widths..... 3/16 ¼ 5/16 3/8 7/16 7/16 ½ 5/8 13/16"

# ROUND

Cut No. 00 to 6 and 8  
Inches.....

2½ 3 3½ 4 4½ 5 6 7 8 10 12 14



Diameter..... 1/16 5/64 7/64 5/32 11/64 3/16 7/32 9/32 11/32 7/16 ½ 5/8"

# SQUARE

Cut No. 00 to 6 and 8  
Inches.....

2½ 3 3½ 4 4½ 5 6 7 8 10 12 14



Thickness..... 5/64 3/32 7/64 1/8 5/32 3/16 7/32 ¼ 9/32 11/32 7/16 5/8"



Cut No. 00 to 6 and 8  
Inches.....

### THREE SQUARE

2½ 3 3½ 4 4½ 5 6 7 8 10 12



Widths..... ⅛ 5/32 7/32 1/4 9/32 11/32 3/8 7/16 1/2 5/8 3/4"

Cut No. 00 to 6  
Inches.....

### METAL SAW

3 3½ 4 5 6 8



Widths..... ⅛ 3/16 7/32 5/16 3/8 1/2"

Cut No. 00 to 6 and 8  
Inches.....

### SLITTING

3 4 5 6 8

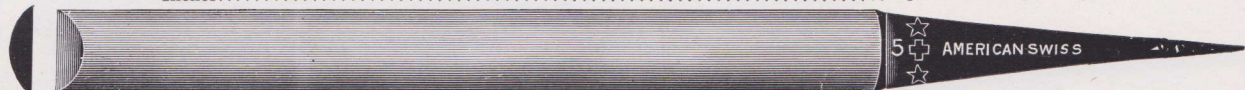


Widths..... 3/8 7/16 1/2 19/32 13/16"

Cut No. 00 to 6 and 8  
Inches.....

### ROUNDING-OFF

Cut on flat side only  
3 4 5 6

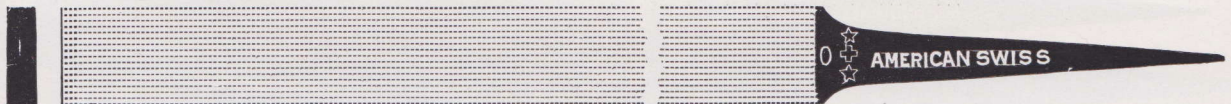


Widths..... 1/4 13/32 1/2 9/16"

### CHECKERING

Cut No. 00 to 2  
Inches.....

6 8



Widths..... 1/2 5/8

### PARALLEL ROUND

Cut No. 00, 0, 2, 4

Diameter in Fractions.....

Diameter in Decimals.....

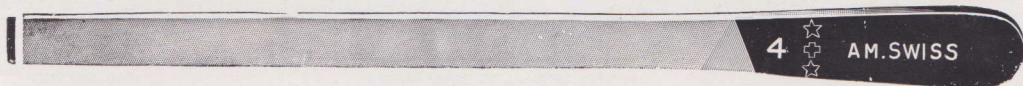
1/16 .062 3/32 .093 1/8 .125 5/32 .156 3/16 .187 7/32 .218 1/4 .250 5/16 .312 3/8 .375



Inches..... 3 4 5 6 7 8 9 10 11 12

### SPARK PLUG FILES

Dimensions..... 3½ inches x ¼ inch. No. 4 Cut





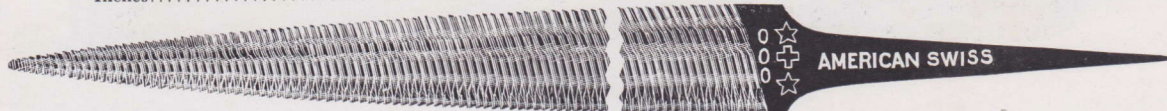
# HALF-ROUND FILES

Coarse open cut for Soft Metals

Cut No. 000

Inches.....

6 8 10



Width.....  $\frac{5}{8}$   $1\frac{3}{16}$  1"

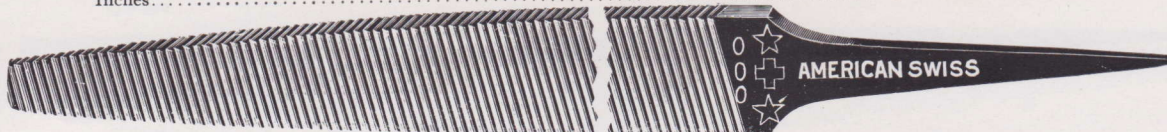
## FLAT

Coarse open cut for Soft Metals

Cut No. 000

Inches.....

6 8 10



Width.....  $\frac{5}{8}$   $1\frac{3}{16}$  1"

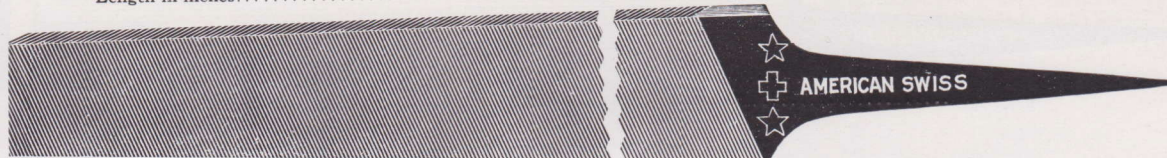
## MILL

Same as Bastard, 2d Cut and Smooth

Cut No. 00, 1 and 2

Length in inches.....

4 6 8 10 12 14



Width.....  $\frac{7}{16}$   $\frac{5}{8}$   $1\frac{13}{16}$  1  $1\frac{3}{16}$   $1\frac{3}{8}$ "

## MILL—TWO ROUND EDGES

Cut No. 00, 1, 2

Inches.....

Same as Bastard 2d Cut and Smooth

8 10 12



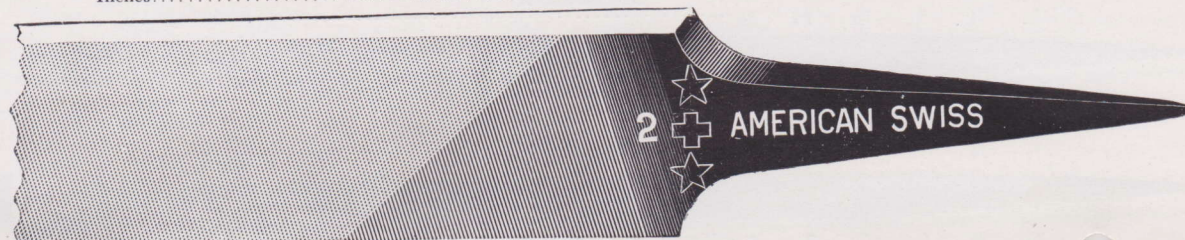
Width.....  $1\frac{13}{16}$  1  $1\frac{3}{16}$ "

## FINISHING OR STRIPPING FILES

Cut No. 2, 4, 6

Inches.....

8 10 12



Width..... 1  $1\frac{1}{8}$   $1\frac{1}{4}$ "



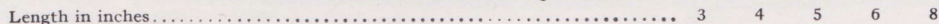
# TAPER SAW FILES



# SLIM TAPER SAW



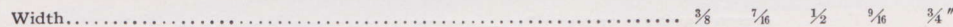
# ROUND EDGE JOINT



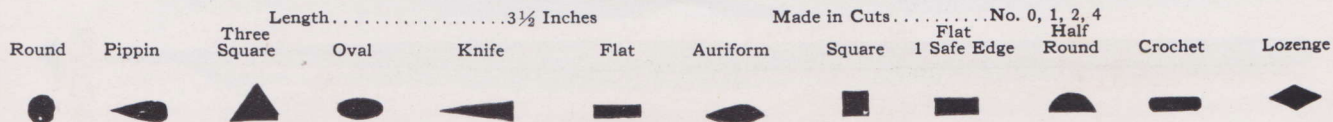
For  
Thickness  
and  
Gauges  
See  
Page 12

# AND SQUARE EDGE JOINT FILES

Cut No.  
0 and 2















# DIE SINKERS' FILES













## NEEDLE FILES—ROUND HANDLES



Length over all.....					4	4¾	5½	6¼	Made in Cuts.....					No. 0, 2, 4, 6
Round Edge Joint	Square	Knife	Flat	Marking Half Round Side Cut only	Round	Three Square	Crossing	Half Round	Slitting	Barrette	Equaling			
														

## ESCAPEMENT FILES—SQUARE HANDLES



Round	Half-Round	Length over all.....5 1/2"	Three-Square	Crossing	Knife	Made in Cuts.....No. 0, 2, 4, 6	Flat	Square	Barrette
									

### SIZE A

Round Shank, 1/4" Diameter

### MACHINE FILES

Length over all, 3 1/4" Made in Cuts No. 00, 0, 2

### SIZE B

Round Shank, 1/8" Diameter



	Pillar 2 Safe Edges	Equalizing Cut 4 Sizes	Three Square	Cant Cut 3 Sizes	Lozenge	Knife	Round	Half-Round	Oval	Pippin	Crochet	Square
SIZE A												
B												

Length, 5"

### SIZE C.

Made in Cuts Nos. 00, 0, 2



Round	Half Round	Oval	Crossing	Pippin	Knife	Crochet	Pillar	Rd. Edge Joint	Three Square	Square	Lozenge
.100"	1/4"	1/4"	5/16"	7/32"	3/8"	3/16" x .095"	3/16" x .095"	3/8" x 3/64"	3/16"	.110"	3/16"
.110"	5/16"			3/8"		1/16" x .115"	3/16" x .115"	Sq. Edge Jt.	1/4"	1/8"	5/16"
1/8"						1/4" x 1/8"	3/8" x 1/8"	1/4" x 1/16"	1/4"	3/16"	3/16"
5/32"						3/8" x 1/8"	3/8" x 1/8"	3/8" x 3/64"	3/16"	3/16"	3/16"
7/16"											
1/4"											

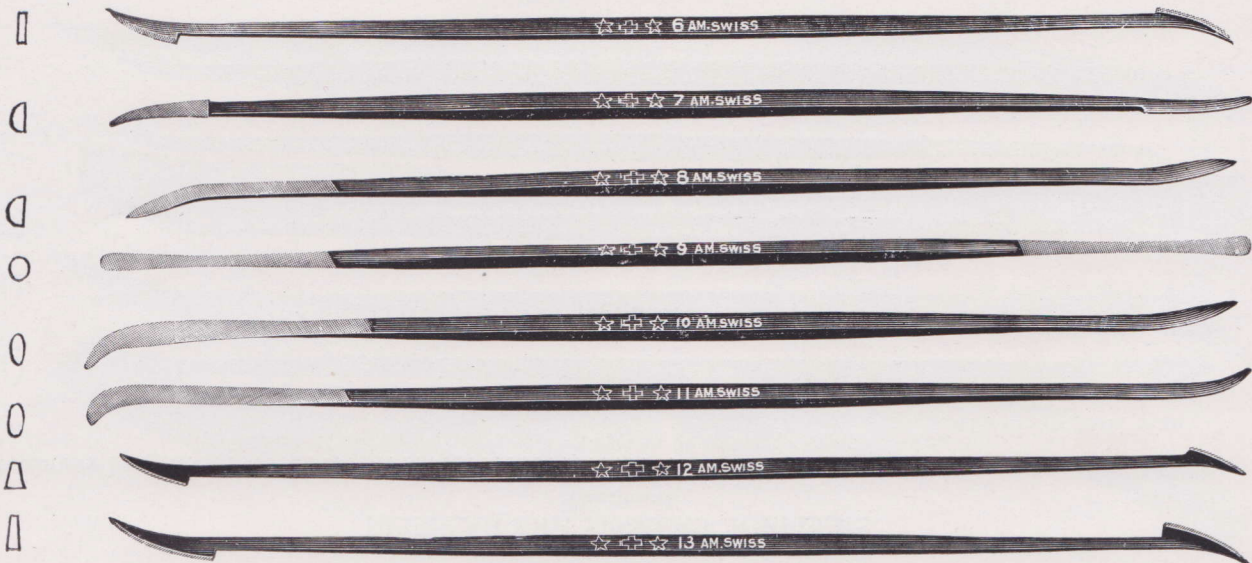
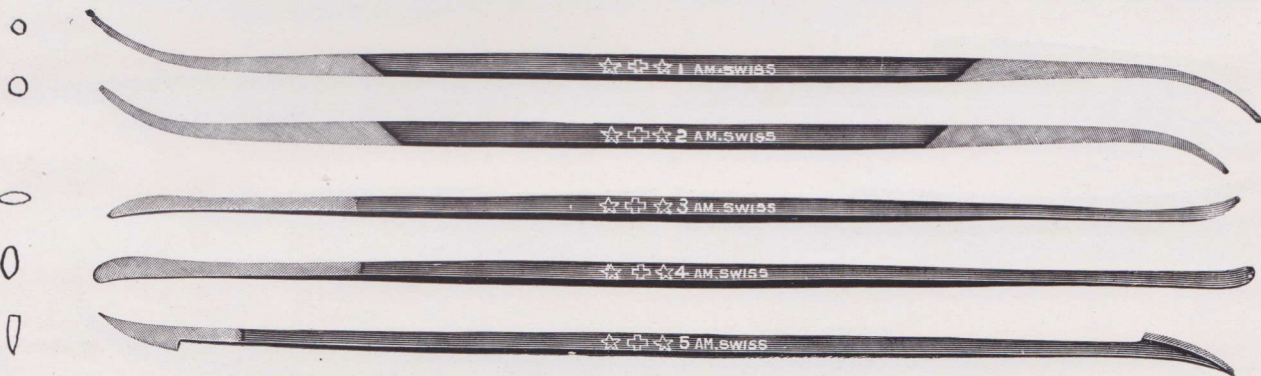


# REGULAR DIE SINKERS' RIFFLERS

Approximate lengths.....Small 6 in. Medium 6½ in. Large 7 in.

Small

Cuts show full size





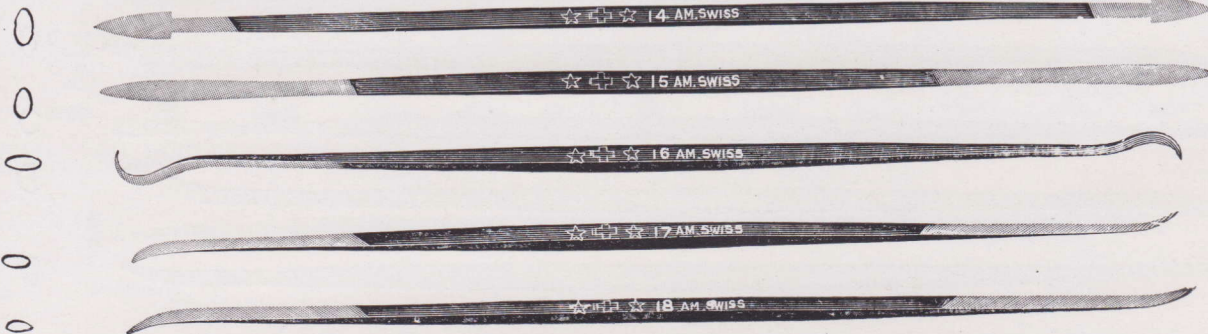
# REGULAR DIE SINKERS' RIFFLERS

(Continued)

Approximate length..... Smal 16 in.    Medium 6½ in.    Large 7 in.

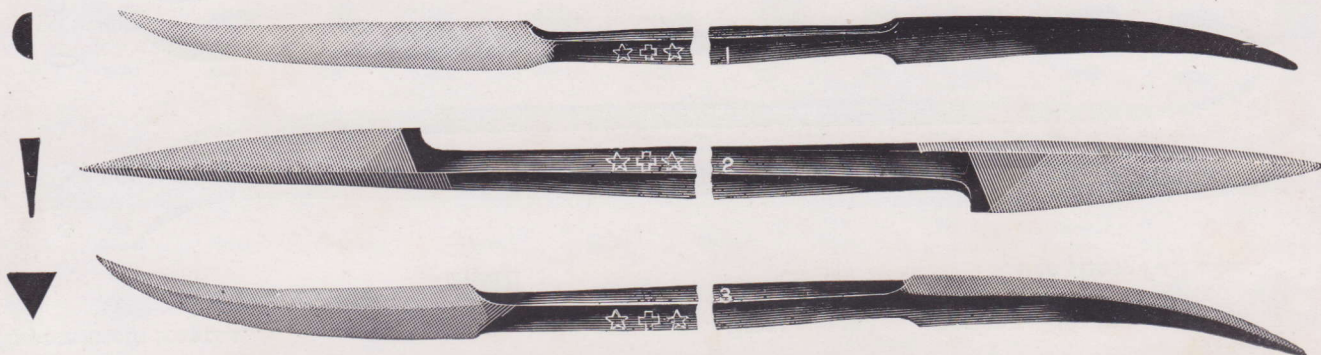
Small

Cuts show full size



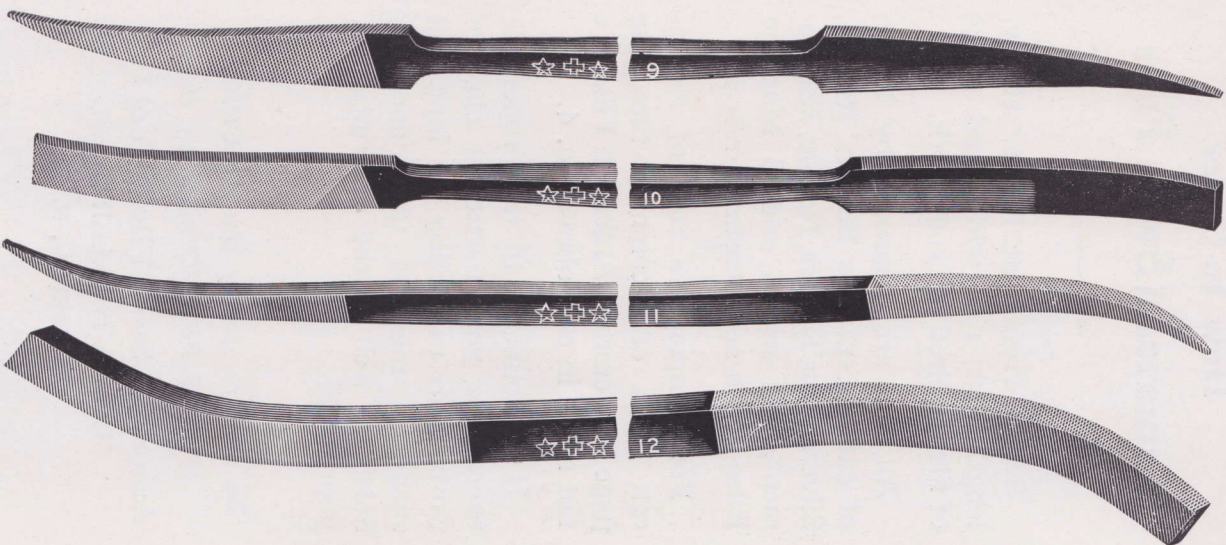
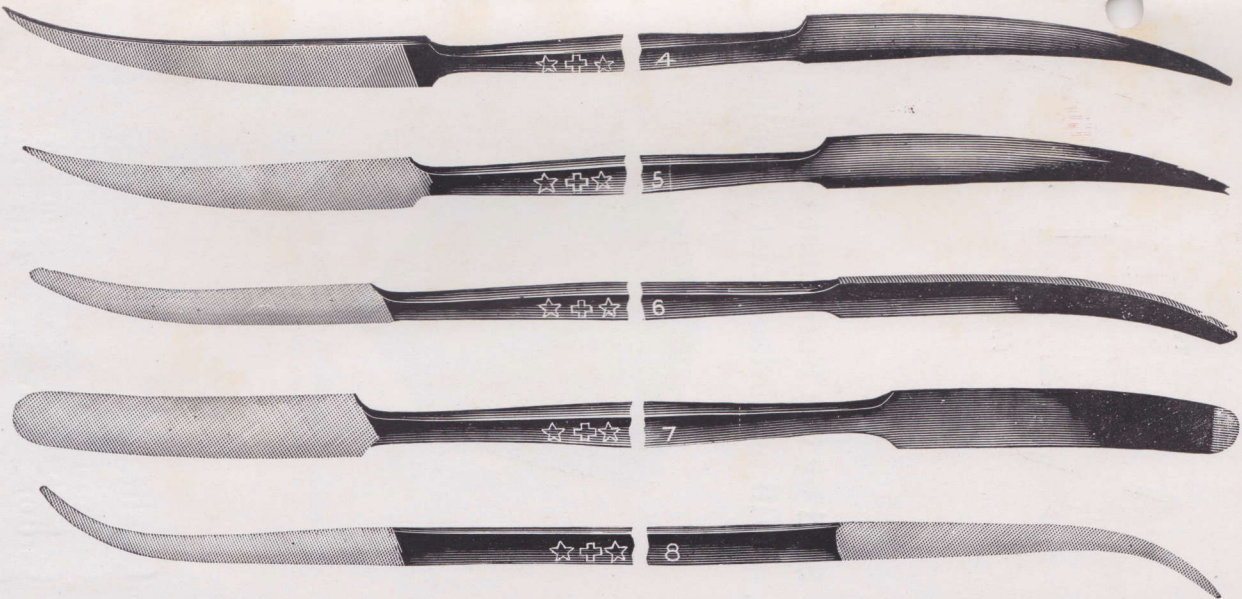
# REGULAR SILVERSMITHS' RIFFLERS

Length.....7½ inches



No. 3—Commutator File



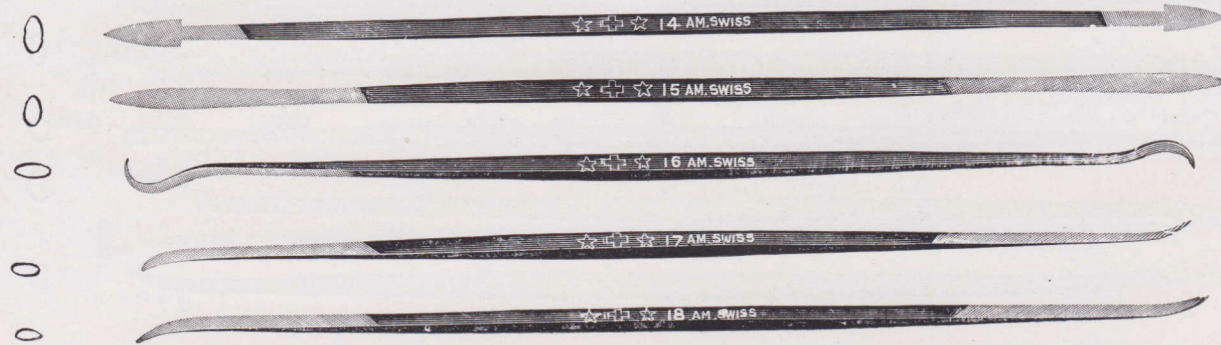




# REGULAR DIE SINKERS' RIFFLERS

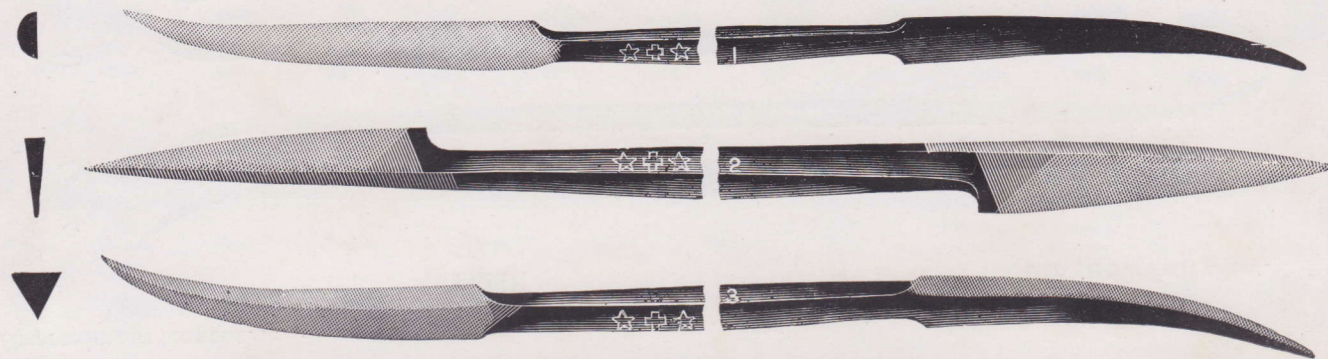
(Continued)

Approximate length..... Smal 16 in.    Medium 6½ in.    Large 7 in.  
Small  
Cuts show full size



# REGULAR SILVERSMITHS' RIFFLERS

Length.....7½ inches



No. 3—Commutator File